Work Order ID 52856

Right Hand

October 15, 2009 2:46:47 PM

Item ID: D206-642-251 **Accept** **Setup Start** **Stop**

Revision ID: M

Item Name: Replacement Skidtube

Start Date: 15/10/2009 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 27/10/2009 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** BP **Date:** 09-10-15 **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	DOCUMENT CONTROL	0.00							
DC	**Memo**	0.00							
Document Control	Photocopy bluefile & type labels per PPP D206-642-251		CHG001	N/A BP					

Draw Nbr	Revision Nbr
D3804	A
IIN-D206-642	M

Right

Work Order ID 52856

October 15, 2009 2:46:47 PM

Item ID: D206-642-251 **Accept** **Setup Start** **Stop**

Revision ID: M

Item Name: Replacement Skidtube

Start Date: 15/10/2009 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 27/10/2009 **Req'd Qty:** 1.00 **Customer:**

Reference: **Run Start** **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
Skidtubes	Skidtubes	0.00							
Skidtubes									

Memo

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

9-10-19

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.
Pick:
Qty ☐Part Number☐ Description☐Batch
A/R☐☐ Aluminum Rod☐ M109213 / M111999 BE 09-10-20

4-Grind weld flush to cap on top surface only. BE 09-10-20

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

AWM 9-10-21

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8167.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time.

9-10-22

Work Order ID 52856

October 15, 2009 2:46:47 PM

Item ID: D206-642-251 **Accept** **Setup Start** **Stop**

Revision ID: M

Item Name: Replacement Skidtube

Start Date: 15/10/2009 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 27/10/2009 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads. 12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804 13-Remove D3286-1 doubers, identify orientation, deburr, then attach them to the workorder 14-Remove indexing edge using DT8741 as per Dwg D3804 15-C'sink GHW rivet holes as per Dwg D3804								
120 QC Quality Control	QC6- Inspect dimensions to drawing **Memo**	0.00 0.00							

9-10-22

9-10-23

27 Oct 2023

Work Order ID 52856

October 15, 2009 2:46:47 PM

Item ID: D206-642-251 **Accept** **Setup Start** **Stop**

Revision ID: M

Item Name: Replacement Skidtube

Start Date: 15/10/2009 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 27/10/2009 **Req'd Qty:** 1.00 **Customer:**

Reference: **Run Start** **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Skidtubes Skidtubes	Skidtubes	0.00				1	4	9-10-23	
	Memo 1-Open crossbolt holes to Ø0.3125" 2- Open Aft cap hole #6. ****no wearplate holes for this skidtube**** 3-Deburr tube and blow out chips from inside the tube	0.00							
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00				1	4	9-10-23	
	Memo	0.00							
150 QC Quality Control	QC3- Inspect Part Finish	0.00				(A)	0		
	Memo	0.00							

2) Sor 10/23

Work Order ID 52856

October 15, 2009 2:46:47 PM

Item ID: D206-642-251 **Accept** **Setup Start** **Stop**

Revision ID: M

Item Name: Replacement Skidtube

Start Date: 15/10/2009 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 2//10/2009 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
Skidtubes	Skidtubes					1	0	9-10-23	
Skidtubes	**Memo**	0.00							
Skidtubes	1-Open holes to finished size as per Dwg D3804, (without cutting fluid) 2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid) 3-Deburr and blow out all chips from inside the tube								
170	QC6- Inspect dimensions to drawing	0.00							
QC		2) S 09/10/23				(XC)	f		
Quality Control	**Memo**	0.00							

Work Order ID 52856

October 15, 2009 2:46:47 PM

Item ID: D206-642-251 **Accept** **Setup Start**

Revision ID: M **Stop**

Item Name: Replacement Skidtube

Start Date: 15/10/2009 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 27/10/2009 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00							
Skidtubes	Skidtubes					1	M 9/10/26		P+O
Skidtubes	**Memo**	0.00							
Skidtubes	1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required 2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up.Allow 12 Hrs. cure time before cutting 10:30 Start Date:☐ 9/10/26 ☐Time:☐ 4:30PM ☐ Finish Date:☐ 9/10/27 ☐Time:☐ 9:15 AM Pick: Qty ☐Part Number☐Description☐Batch A/R☐☐Sikaflex-291☐ M11391 ☐☐ Sikaflex expire date:☐ 10/2/30								
190	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									

2) 8 09/10/07

Dart Aerospace Ltd

W/O: 52856	WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector
9/10/23	* 180	Perm chng. Stock web is missing holes for Rev or wear plates 1.— ~~Drill~~ to be Drilled before installing web in skid tube 2.— Re alodine as per QS2005	KM 9/10/23	N/A NCR			09/10/23

Part No: D206-642-251 **PAR #:** _____ **Fault Category:** Skid tubes **NCR:** ~~Yes~~ No See w/o 52858 **DQA:** _____ **Date:** 05.11.25

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B — **Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
9/10/23	180	Stock web is missing hole ~~for~~ not Drilled on w/o 49679 * missed at inspection	QS1042	Drill hole in web at correct Location Per Dwg. - Re Alodine Per QS2005	KM 9/10/23	09/10/23	QS1042	09/10/23
		RC: LOA	QS1042	recycled on w/o 52858 w/ same issue			QS1042	

NOTE: Date & initial all entries

Work Order ID 52856

October 15, 2009 2:46:47 PM

Item ID: D206-642-251 **Accept** **Setup Start** **Stop**

Revision ID: M

Item Name: Replacement Skidtube

Start Date: 15/10/2009 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 27/10/2009 **Req'd Qty.** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200		0.00							
Skidtubes	Skidtubes								
Skidtubes	**Memo**	0.00							

Skidtubes

1-remove alodine from around hole and prepare for welding BE 09/10/27

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty☐Part Number☐Description☐Batch

A/R☐☐Aluminum Rod☐ M112507 BE 09/10/27

3-Grind welds flush as per Dwg D3804. DP 9-10-27

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/R☐SS Rod☐ NONE BE 09/10/28

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

DP 9-10-28

Work Order ID 52856

October 15, 2009 2:46:47 PM

Item ID: D206-642-251 **Accept** **Setup Start**

Revision ID: M **Stop**

Item Name: Replacement Skidtube

Start Date: 15/10/2009 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 27/10/2009 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 HandFinish Hand Finishing	HandFinishing	0.00							
	Memo Install D2680-041 Nut Plate as per Dwg D3804	0.00							
220 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	Memo	0.00							
230 QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							

9-10-28

QC Solabs 09.10.28

=) Solabs

Work Order ID 52856

October 15, 2009 2:46:47 PM

Item ID: D206-642-251 **Accept** **Setup Start**

Revision ID: M **Stop**

Item Name: Replacement Skidtube

Start Date: 15/10/2009 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 27/10/2009 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 **Memo**	0.00 0.00				41	0		
250 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M112 149 **Memo** START TIME: 7:30AM OVEN TEMPERATURE: 320°F FINISH TIME: 8:00AM	0.00 0.00				41	0		
260 QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00				41			

Work Order ID 52856

October 15, 2009 2:46:48 PM

Item ID: D206-642-251 **Accept** **Setup Start** **Stop**

Revision ID: M

Item Name: Replacement Skidtube

Start Date: 15/10/2009 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 27/10/2009 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	HandFinishing	0.00							
HandFinish									
Hand Finishing	**Memo**	0.00							
	1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.								
280	HandFinishing	0.00							
HandFinish									
Hand Finishing	**Memo**	0.00							
	1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive A/R☐☐Sikaflex-291☐ M112391 Sikaflex expire date:☐ 10/20 2-Wing Walk as per Dwg D3804 and QSI 005 4.4☐ Batch: M112106								

MO 09/10/29 X1

MO 09/11/05 X1

09/10/29

Install wear plate as per dwg

> BK09-11-5.

Work Order ID 52856

October 15, 2009 2:46:48 PM

Item ID: D206-642-251 **Accept** **Setup Start** **Stop**

Revision ID: M

Item Name: Replacement Skidtube

Start Date: 15/10/2009 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 27/10/2009 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
290 QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00				20	0		
300 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00				20	0		
310 Packaging Packaging	Packaging **Memo** Identify and pack for shipping as per PPP D206-642-251 Location: PPP Rev: PPP 52522	0.00 0.00							

Work Order ID 52856

October 15, 2009 2:46:48 PM

Item ID: D206-642-251 **Accept** **Setup Start** **Stop**

Revision ID: M

Item Name: Replacement Skidtube

Start Date: 15/10/2009 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 27/10/2009 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
320	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00				_____	09/11/06		
Quality Control							JMF 09-11-05		

Picklist Print

October 15, 2009 2:46:46 PM

Work Order ID: 52856

Parent Item: D206-642-251RevA

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 15/10/2009 **Required Date:** 27/10/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Fin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2620RevB Skidtube, 206 Skidtube		Manufactured	No			110	Each	19.0000	1.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	19	
45898	19	

9-10-19

D3286-1RevA Doubler		Manufactured	No			110	Each	27.0000	2.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	27	
44286	1	
46440	6	
47692	20	

9-10-22

D2647RevF Cap		Manufactured	No			110	Each	27.0000	1.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	27	
10773	7	
43846	20	

86 09/10/20

Picklist Print

October 15, 2009 2:46:47 PM

Work Order ID: 52856

Parent Item: D206-642-251RevA

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 15/10/2009 **Required Date:** 27/10/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
CR3212-4-04		Purchased	No			180	Each	704.0000	52.0000			
Cherry Rivet												

Warehouse Location	Loc Qty	Loc Code		
Main Warehouse				
ST	704			
109297	26			
109740	16			
110153	6			
111127	78			
112314	378		52	H 9/10/26
112612	200			

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2654-3RevE1		Manufactured	No			180	Each	10.0000	1.0000			
Web												

Warehouse Location	Loc Qty	Loc Code		
Main Warehouse				
ST	10			
48679	10		1	H 9/10/26

Picklist Print

October 15, 2009 2:46:47 PM

Work Order ID: 52856

Parent Item: D206-642-251RevA

Parent Item Name: Replacement Skidtube

Comments.

Start Date: 15/10/2009 **Required Date:** 27/10/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2649RevB1		Manufactured	No			200	Each	617.0000	20.0000			
Cross Bolt Spacer												

Warehouse Location	Loc Qty	Loc Code		
Main Warehouse				
LG	83			
51529	83			
Main Warehouse				
ST	534			
36013	5			
47112	383			
48271	146		20	BE 09/10/27

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3286-3RevA		Manufactured	No			200	Each	43.0000	2.0000			
Spacer												

Warehouse Location	Loc Qty	Loc Code		
Main Warehouse				
ST	43			
35048	1			
41900	1			
43862	1		1	BE 09/10/27
46643	40		1	BE 09/10/27

Picklist Print

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Work Order ID: 52856

Parent Item: D206-642-251RevA

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 15/10/2009 **Required Date:** 27/10/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
CCR264SS3-3		Purchased	No			210	Each	267.0000	2.0000			
Cherry Rivet												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	267	
111548	52	
111827	115	
112314	100	

9-10-28

(2)

CR3212-4-03		Purchased	No			210	Each	310.0000	2.0000			
Cherry Rivet												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	310	
111359	96	
112314	200	
15984	14	

9-10-28

M110139

(2)

Picklist Print

October 15, 2009 2:46:47 PM

Work Order ID: 52856

Parent Item: D206-642-251RevA

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 15/10/2009 **Required Date:** 27/10/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2680-041RevB1		Manufactured	No			210	Each	79.0000	1.0000			
Nut Plate												
D3805-043RevA		Manufactured	No			270	Each	0.0000	1.0000	X1	mo 09/11/04	
Wearplate Assembly Fwd, HighGear												
D3805-047RevA		Manufactured	No			270	Each	0.0000	1.0000	X1	mo 09/11/04	
Wearplate Assembly Aft, High Gear												
AN3-37A		Purchased	No			270	Each	773.0000	7.0000			
Bolt												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	79	
33061	14	
44086	65	

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	773	
105425	273	
111668	500	

Picklist Print

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Work Order ID: 52856

Parent Item: D206-642-251RevA

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 15/10/2009 **Required Date:** 27/10/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L washer		Purchased	No			270	Each	4,446.000	7.0000			

Warehouse Location	Loc Qty	Loc Code
OFFSHORE		
FG	100	
103585	100	
Main Warehouse		
ST	4346	
112116	993	
112612	3353	

X7 mo 09/11/04

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L3 Nut		Purchased	No			270	Each	3,503.000	7.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	3503	
110844	32	
111274	41	
111668	930	
112314	2000	
112385	500	

X7 mo 09/11/04

Picklist Print

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Work Order ID: 52856

Parent Item: D206-642-251RevA

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 15/10/2009 **Required Date:** 27/10/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Pick Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3873-1RevA		Manufactured	No			270	Each	73.0000	14.0000			
Bushing												

Warehouse Location	Loc Qty	Loc Code		
Main Warehouse				
ST	28			
46757	6			
48267	22			
Main Warehouse				
~~ST139~~	45			
50479	45		X14	MO 09/11/04

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Pick Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10L		Purchased	No			270	Each	5,969.000	2.0000			
Washer												

Warehouse Location	Loc Qty	Loc Code		
Main Warehouse				
ST	5969			
101291	16			
104885	153			
105793	236			
~~109632~~	564		X2	MO 09/11/04
110985	5000			

Picklist Print

October 15, 2009 2:46:47 PM

Work Order ID: 52856

Parent Item: D206-642-251RevA

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 15/10/2009 **Required Date:** 27/10/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-08		Purchased	No			270	Each	3,035.000	2.0000			
Screw												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	3035	
110467	192	
110552	843	
110835	2000	

X2 mo 9/11/09

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2651-1RevB		Manufactured	No			270	Each	403.0000	8.0000			
Plug												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	403	
43990	125	
45490	28	
51530	250	

X8 mo 9/10/29

Picklist Print

October 15, 2009 2:46:47 PM

Work Order ID: 52856

Parent Item: D206-642-251RevA

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 15/10/2009 **Required Date:** 27/10/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2651-3RevB O-Ring		Manufactured	No			270	Each	1,035.000	8.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	1035	
43849	3	
46114	1032	

X8 MD 09/10/29

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-4-06 Screw		Purchased	No			270	Each	77.0000	1.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	77	
109061	77	

X1 MD 09/10/29

Picklist Print

October 15, 2009 2:46:47 PM

Work Order ID: 52856

Parent Item: D206-642-251RevA

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 15/10/2009 **Required Date:** 27/10/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416		Purchased	No			270	Each	5,441.000	1.0000			
Washer												

Warehouse Location	Loc Qty	Loc Code	
Main Warehouse			
ST	5441		
102929	2		
105906	4		
106277	2		
107321	23		
107939	114		
108161	521		X1 MD 09/10/29
108827	31		
109249	69		
110523	340		
111279	101		
111916	482		
112314	3752		
16941	0		

Picklist Print

October 15, 2009 2:46:47 PM

Work Order ID: 52856

Parent Item: D206-642-251RevA

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 15/10/2009 **Required Date:** 27/10/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2646RevC		Manufactured	No			280	Each	53.0000	1.0000			

Aft Cap

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	53	
20208	0	
43801	1	
46327	4	
48109	48	

XT MD 09/11/04

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

1) MATERIAL: N/A
2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 -POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
7) IDENTIFICATION: NONE
8) WEIGHT: 12.5 lb
9) WELD PER DART QSI 004
10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
 THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

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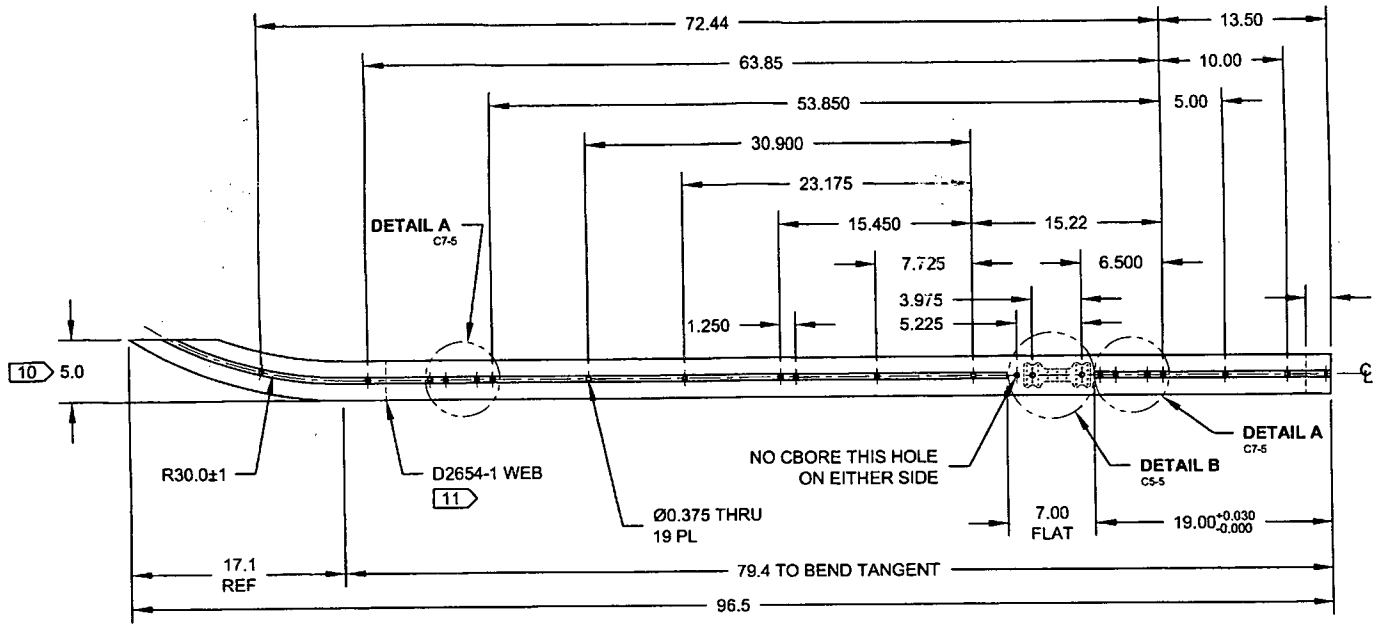
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A	NEW ISSUE	MB	08.07.07

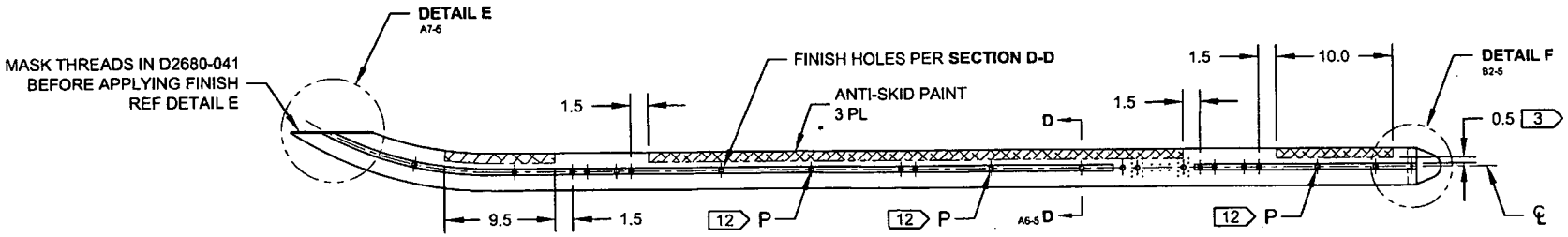
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D3804-041 BENDING/DRILLING DETAIL



D3804-041 ASSEMBLY/FINISHING DETAIL

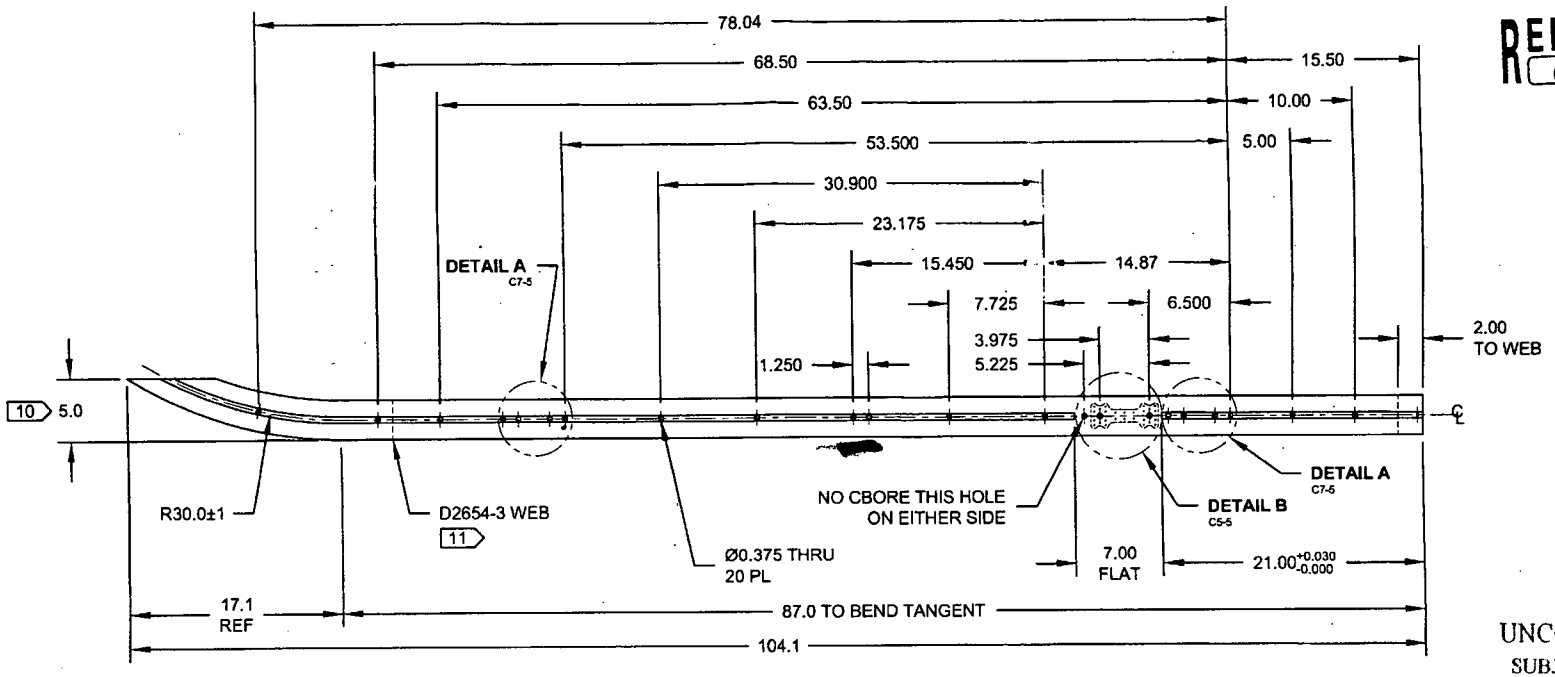
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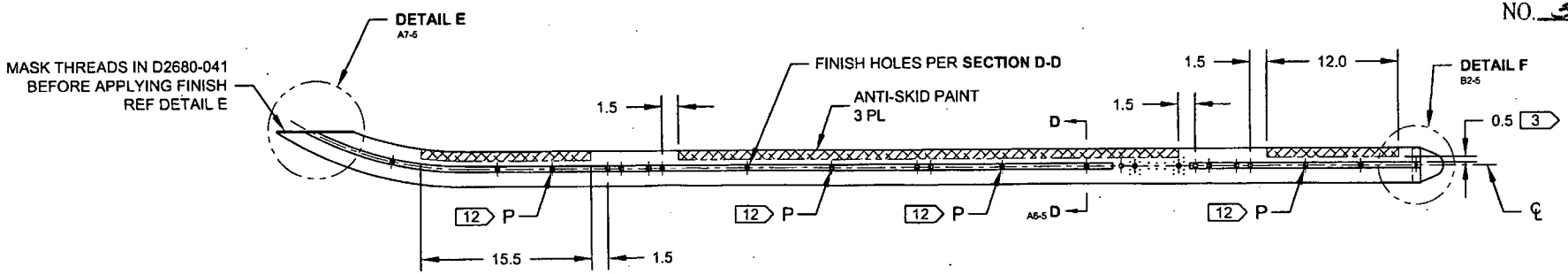
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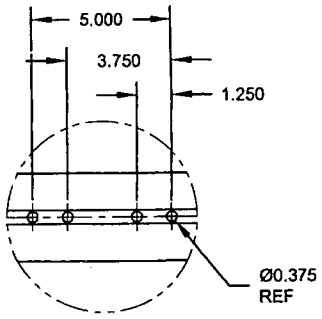


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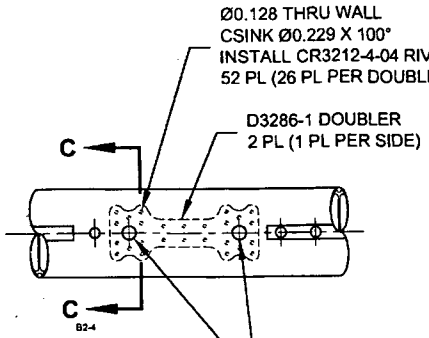
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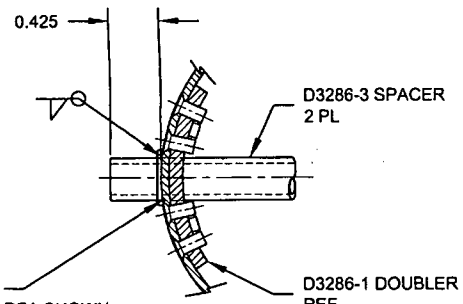
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DETAIL A D6-2 C2-2 D6-3 C2-3
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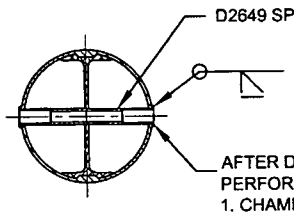


DETAIL B C3-2 C3-3
SCALE NONE



TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
3. ENLARGE HOLES IN D3286-1 TO Ø0.500
4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
5. RIVET D3286-1 TO TUBE
6. INSERT D3286-3 SPACER
7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C C6-4
PARTIAL SECTION
SCALE NONE



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

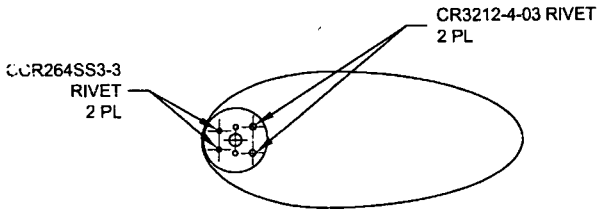
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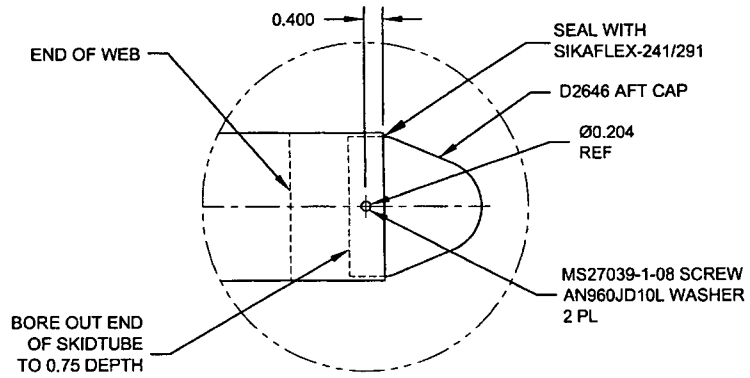
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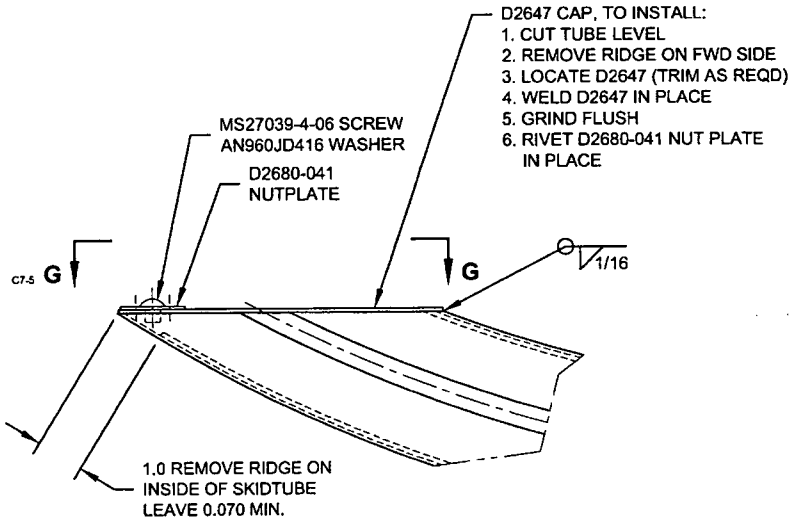
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DETAIL F
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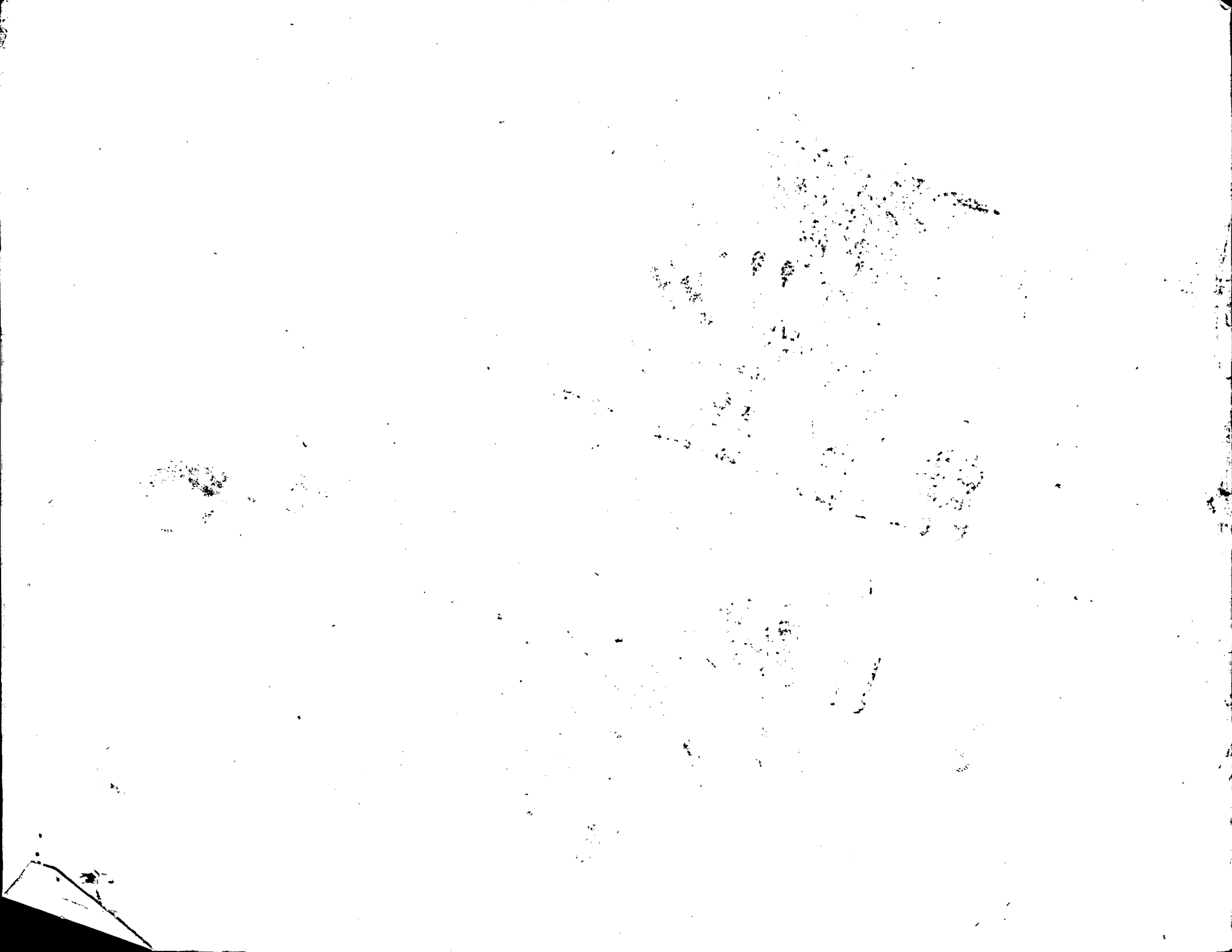


DETAIL E
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NO. 211

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 52411
Part number: D206-642-541
Description: 206 skid
Welding Process: Tig[✓] Mig[]
Base materiel: Aluminium
Current: AC[✓] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[✓] fail[]
Penetration:	pass[✓] fail[]

UNACCEPTABLE

Cracks:	pass[✓] fail[]
Undercut:	pass[✓] fail[]
Pin holes:	pass[✓] fail[]
Overlap (cold lap)	pass[✓] fail[]
Porosity (surface):	pass[✓] fail[]
Coloration:	pass[✓] fail[]

Qualifier Pat. Dunl **Date of Test Coupon** 09-10-09

Welder Barclay Elliott **Date of Test Coupon** 09-10-09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld